

Date: Wednesday, 1/31/2007 2:35:28 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 30512		
Estimate Number	: 10022		
P.O. Number	: N/A	Part Number	: D205634011
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 30511	Material	: N/A
Written By	:	Due Date	: 2/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.02.01</u>		
Comment	: Est Rev: 02.08.28 Removed QC5 from Step 5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D205-634-011

CHG004

KS 07.02.08 ①

2.0	30512A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 30512A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit 30052

1 D205-634-041 Skidtube Assembly(ref) 30512A

07/03/22 SJK

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/03/22 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/03

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:35:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 30512

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: H

6/7/3/22 (1) (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/07/03/23

Job Completion



U 8-03-23

30512A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:36:00 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 30512A		
Estimate Number	: 10023		
P.O. Number	: N/A	Part Number	: D205634041
This Issue	: 1/31/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2580 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30511A	Drawing Revision	: C
		Material	: N/A
Written By	: <u>JA 07.02.01</u>	Due Date	: 2/28/2007
Checked & Approved By	: <u>JA 07.02.01</u>	Qty:	1 Um: Each
Comment	: Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev: O 06.02.28 Added paperwork EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634 CHG001

N/A

2.0	D25001190	Ext'n -1' Beam Tube 4"
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Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B25858

JD 7-2-19

3.0	D2596	205 Web
-----	-------	---------



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	D29723

JD 7-2-22

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

JD 7-2-19

JD 7-2-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 1/31/2007 2:36:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30512A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid *pm 07-02-20*  
6-Countersink holes as per Dwg D2580 without cutting fluid *pm 07-02-20*  
7-Deburr and blow out all chips from inside of tube *pm/JB 7-2-22*  
8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting *pm/JB 7-2-22*  
Pick:  
Qty Part Number Description Batch  
A/R Sikaflex-291 *m102672*  
Sikaflex expire date: *7-2-28*  
Start Time: *7-15* Date: *7-2-22*  
Fin Time: *210pm* Date: *7-3-1*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*DP 7-3-1*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

*pm/EL*

*7-3-5*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Lot 0306 @*

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step *B29486*

*RE 07-03-07*

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30512A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

~~20~~ D2579 Spacers *B30220 BE 07-03-08*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

*BE 07-03-08*

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*M103317 BE 07-03-07*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*M103317 BE 07-03-08*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*fm 07-03-07(1)*

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

*fm 07-03-08(1)*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*fm 07-03-08(1)*

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

*fm 07-03-08(1)*

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*fm 07-03-08(1)*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*11/07/03/12*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11/07/03/12*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*HS*

*07-03-14*

*(1)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 1/31/2007 2:36:01 PM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30512A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/03/19

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



2003-190



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-1

Wearplate

B29488

17.0

D25773

Wearplate Aft



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-3

Wearplate

B29960

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-5

Wearplate

B28639

19.0

ALS71032130

Insert



Comment: Qty.: 44 Each(s)/Unit Total: 44 Each(s)

Pick:

Qty

Part Number

Description

Batch

44

ALS7-1032-130

Inserts

M103706

arm 07/03/19 4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:36:01 PM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30512A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44 Each(s)/Unit Total : 44 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	M10832

21.0

AN34A

Bolt



Comment: Qty.: 44 Each(s)/Unit Total : 44 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	M100857

22.0

D25941

Plug



Comment: Qty.: 16 Each(s)/Unit Total : 16 Each(s)

plug

Batch: B29490

23.0

D25943

O-Ring



Comment: Qty.: 16 Each(s)/Unit Total : 16 Each(s)

o-ring

Batch: B27168

24.0

D2855

Cap



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Cap

Batch: B27488

25.0

AN35A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Bolt

Batch: M15205

a.m 07/03/19 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ED Date: 07/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30512A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Washer

Batch:

M 1028832

07/03/19

a.m. ①

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M 103497

Sikaflex expire date:

07/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

M 103497

Sikaflex expire date:

07/10

a.m. 07/03/19

①

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M 103480

F.L/a.m

Batch:

07/03/20

①

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PPP

B 30512

07/03/20

①

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



07/03/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

# 00 08.28  
UP 00.08.28

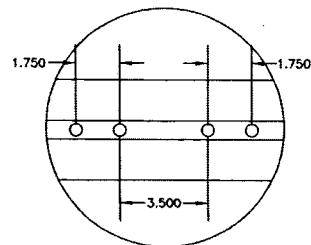
EFFECTIVE DEOS  
98/12/14  
DEO 9124  
DEO 9183

#### GENERAL NOTES:

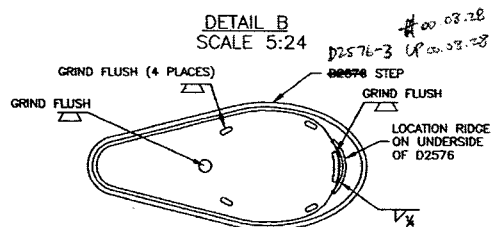
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

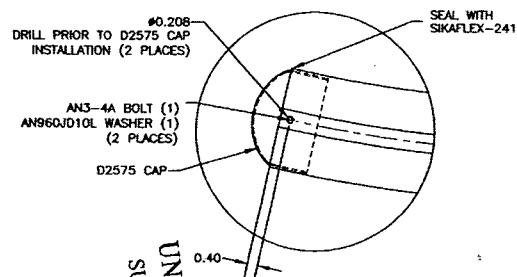
DETAIL A  
SCALE 5:24



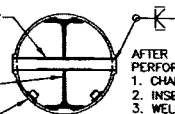
DETAIL B  
SCALE 5:24



DETAIL C  
SCALE 5:24

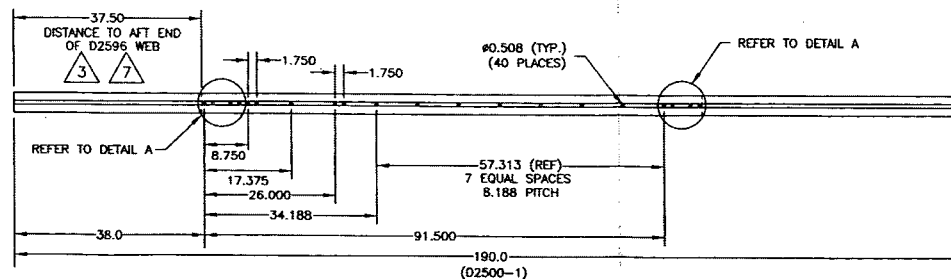


SECTION D-D  
SCALE 5:24

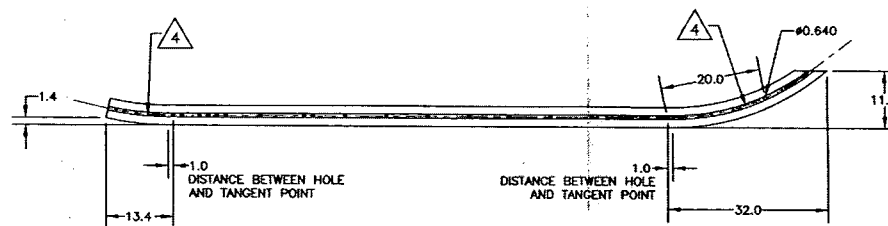


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

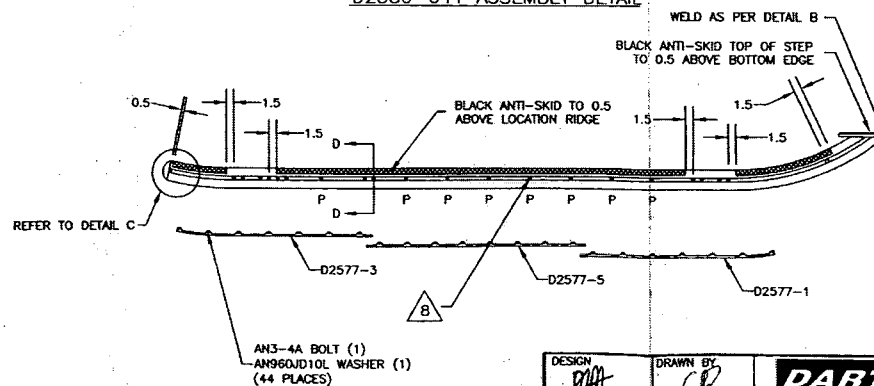
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL

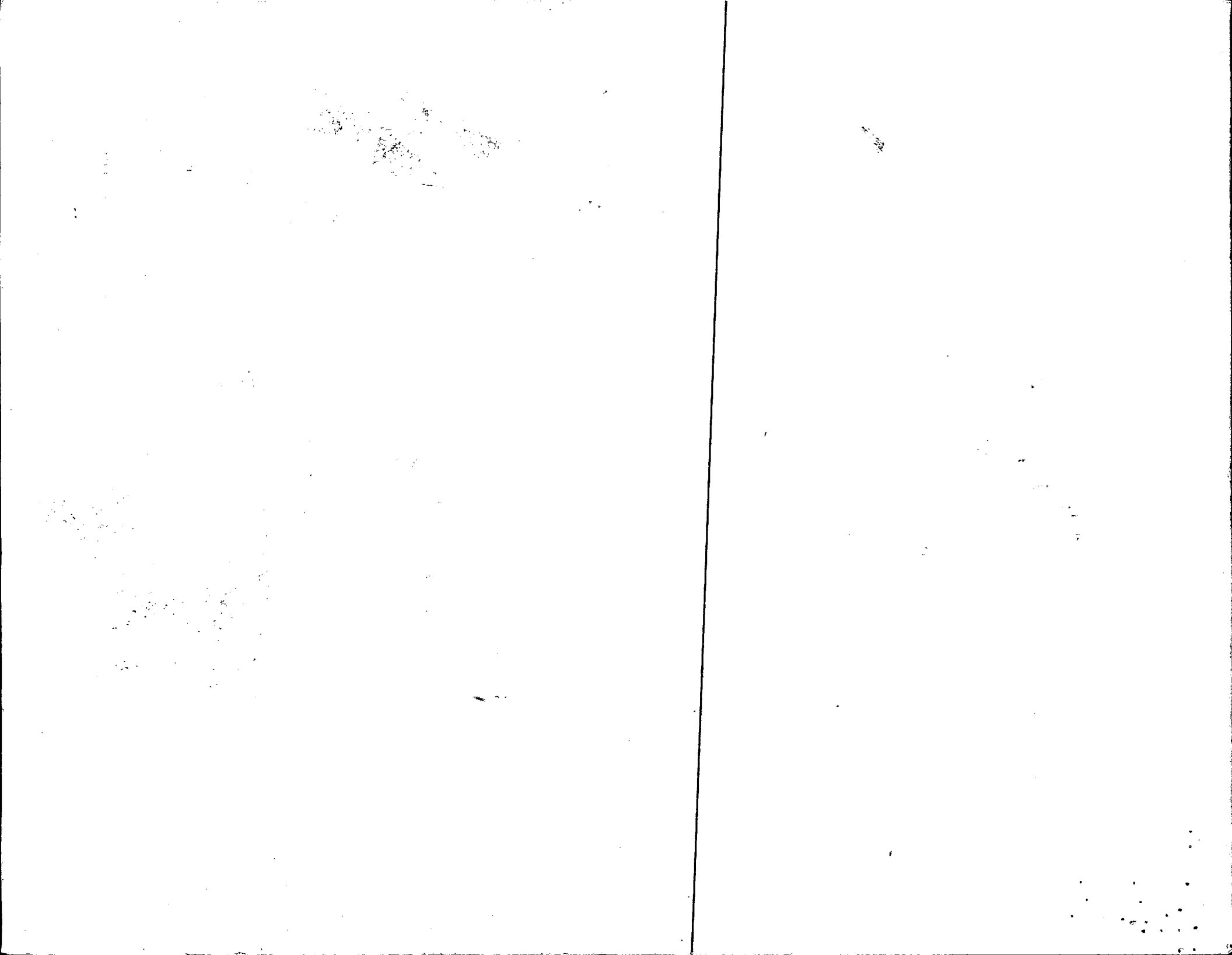


D2580-041 ASSEMBLY DETAIL



RELEASED  
98/09/17 DS

DESIGN DART	DRAWN BY DART	DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED DART	APPROVED DART	DRAWING NO. D2580
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY
		REV. C SHEET 2 OF 2 SCALE 1:24



**Jason Murdoch**

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**From:** Bill Beckett [bbeckett@dartaero.com]  
**Sent:** Monday, February 05, 2007 1:10 PM  
**To:** 'Jason Murdoch'  
**Cc:** 'L Lacelle'  
**Subject:** RE: sikaflex-291

Jason,  
Yes.  
Bill

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** February 5, 2007 12:49 PM  
**To:** 'Bill Beckett'  
**Subject:** sikaflex-291

Bill,  
We have 25 tubes of sikaflex-291, batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com  
Q.C. COORDINATOR

NO. 97

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D205634041 / B30510 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/08 Qualifier Awid Awad

Date: Friday, 09/02/2007 9:59:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-635 / D204-635
Job Number	: 30722		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z-CUSTOM ECN953/908
This Issue	: 09/02/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	:	Due Date	: 16/02/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563N4

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

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 avec ✓

7/4/27 SQ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 RETURN TO STOCK

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Date: Friday, 09/02/2007 9:59:35 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-635 / D204-635
Job Number	: 30722		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z-CUSTOM ECN952/908
This Issue	: 09/02/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	:	Due Date	: 16/02/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

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avec ✓*

*7/4/27 SQ*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
RETURN TO STOCK

*7/4/27 SQ*